

SPLIT

Date: Wednesday, 16/04/2008 3:53:38 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 38646		Part Number	: D33191		
Estimate Number	: 10437		Drawing Number	: D3319 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 16/04/2008	S.O. No. :	Drawing Revision	: B		
Prsh Rev.	: NC		Material	:		
First Issue	: 11	Type :	Due Date	: 25/04/2008		
Previous Run	: 38112		Qty:	12	Um:	Each
Written By	:		Comment	:		
Checked & Approved By	: <i>DD 08-4-18</i>		Est: B	05.10.14	Added step 9, dwg rev B	
Comment	:		KJ/EC	Est Rev:C Now on Waterjet 06-10-26 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s) 1010/1025/A21/6aA SHEET .048 Batch: <i>106348 B 8-4-18</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: <i>B</i> <i>B 8-4-18</i> Prog Rev: <i>B</i>		
2-Deburr if necessary <i>B 8-4-18</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<i>B 8-4-18</i>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<i>6/20/18 8/12</i>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<i>1/2</i>		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary		
<i>Done &amp; file 8/22</i> <i>6/20/18</i>		

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Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B  
2- Form flat on press using DT8776 block

JB 08/04/21

(13)

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3  
2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod M1054390

SP 08-04-29

(OK)

(TL)

SP 08-04-29

(OK)

SP 08-04-

9.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

1338646  
D 33191  
29/04/2008  
S. 150  
#1 13.36  
#2 345.7  
#3 345.7  
#4 345.7  
M105  
F  
F  
F  
F

08-04-29

(OK)

08/04/29

Date: Tuesday, 10/04/2000 3:35:38 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #: Machine Or Operation:

Description :

and Stock

Location: \_\_\_\_\_

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/30 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



U. 08.04.30

DART AEROSPACE LTD	Work Order:	38646
Description: Wearplate	Part Number:	D3319-1
Inspection Dwg: D3319	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

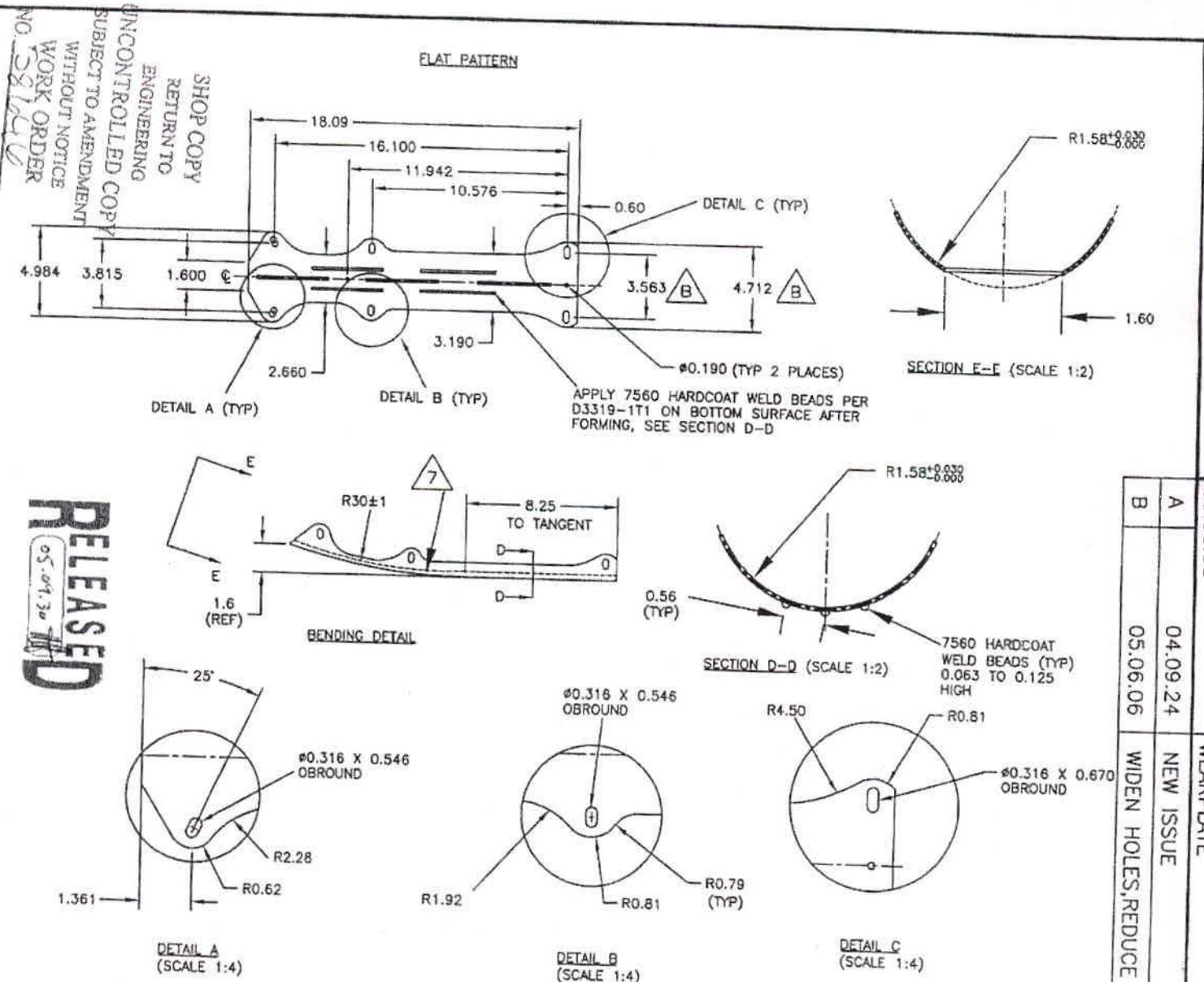
## X First Article      Prototype

Measured by: B	Audited by: J	Prototype Approval: N/A
Date: 8-4-19	Date: 08/04/19	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	✓

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	PF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
11/11/05	11/11/05	D3319
DATE		REV. B
05.06.06		SHEET 1 OF 5
A	04.09.24	SCALE
B	05.06.06	1:8



**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"